

Date: Wednesday, 2/20/2008 4:25:00 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABLE GUARD
Job Number : 37556	
Estimate Number : 12459	
P.O. Number :	Part Number : D29167
This Issue : 2/20/2008 S.O. No. :	Drawing Number : D2916 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 27907	Material :
Written By :	Due Date : 3/5/2008 Qty: 4 Um: Each
Checked & Approved By : <u>080221</u>	
Comment : Est Rev: A New Issue 06-06-19 JLM	
Est Rev: B Now water jet 06-07-14 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 0.2730 sf(s)/Unit Total : 1.0920 sf(s)

UHMW 1" Black

batch: 107067IB 8-2-25

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2916

Dwg Rev: BProg Rev: BIB 8-2-25

(4)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

BATCH: 1070671-Mill as per Folio FA2916-7 Rev: A & Dwg D2916 Rev: B

2-Deburr per dwg D2916

H.A./m2 08/03/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LOT Date: 08/03/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:25:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 37556

Part Number: D29167

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A/mf 08/03/06

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SC 08/03/07

(4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *28/3/10*

(4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/11

(4)

Job Completion



2008/3/10

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

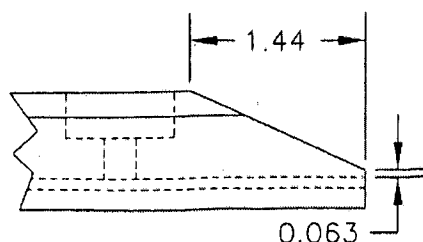
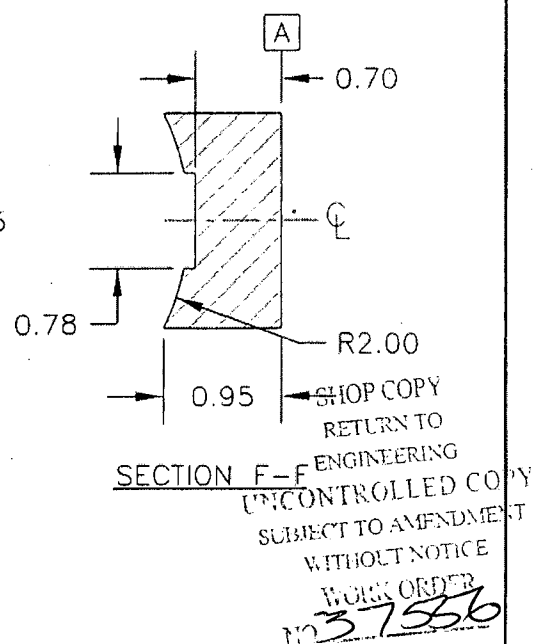
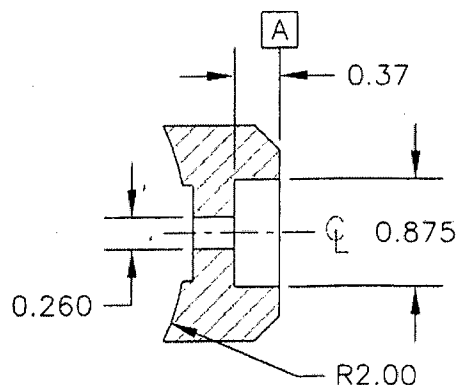
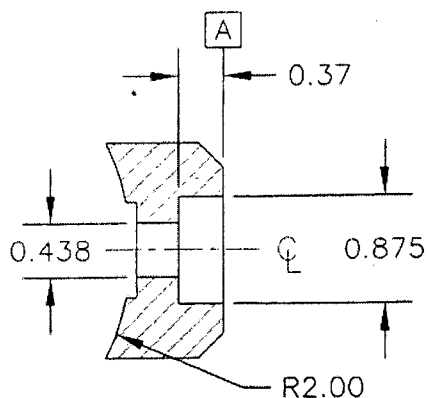
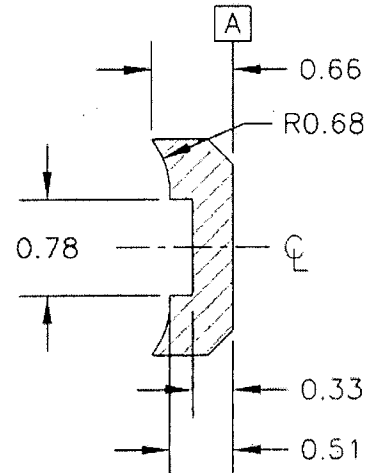
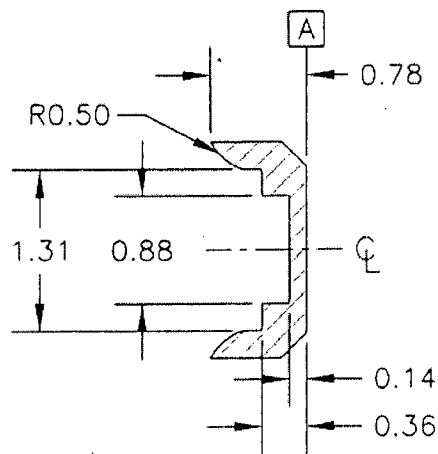
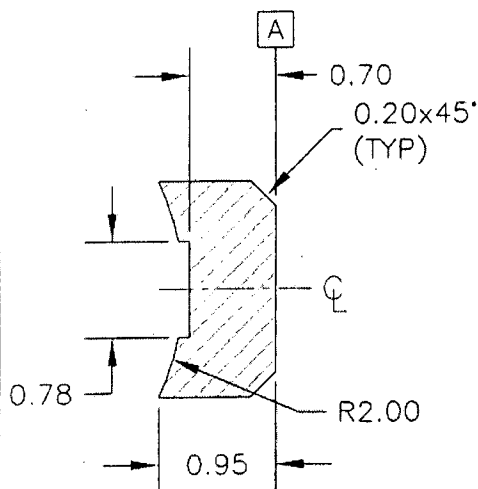
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

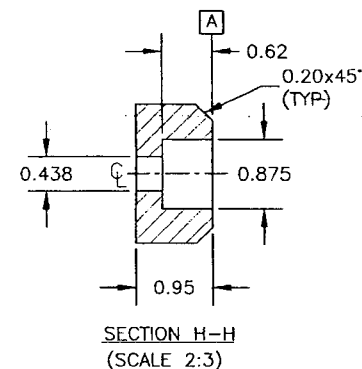
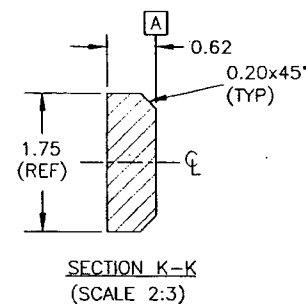
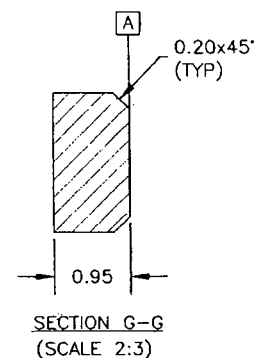
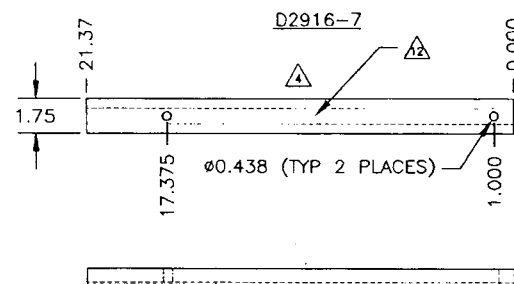
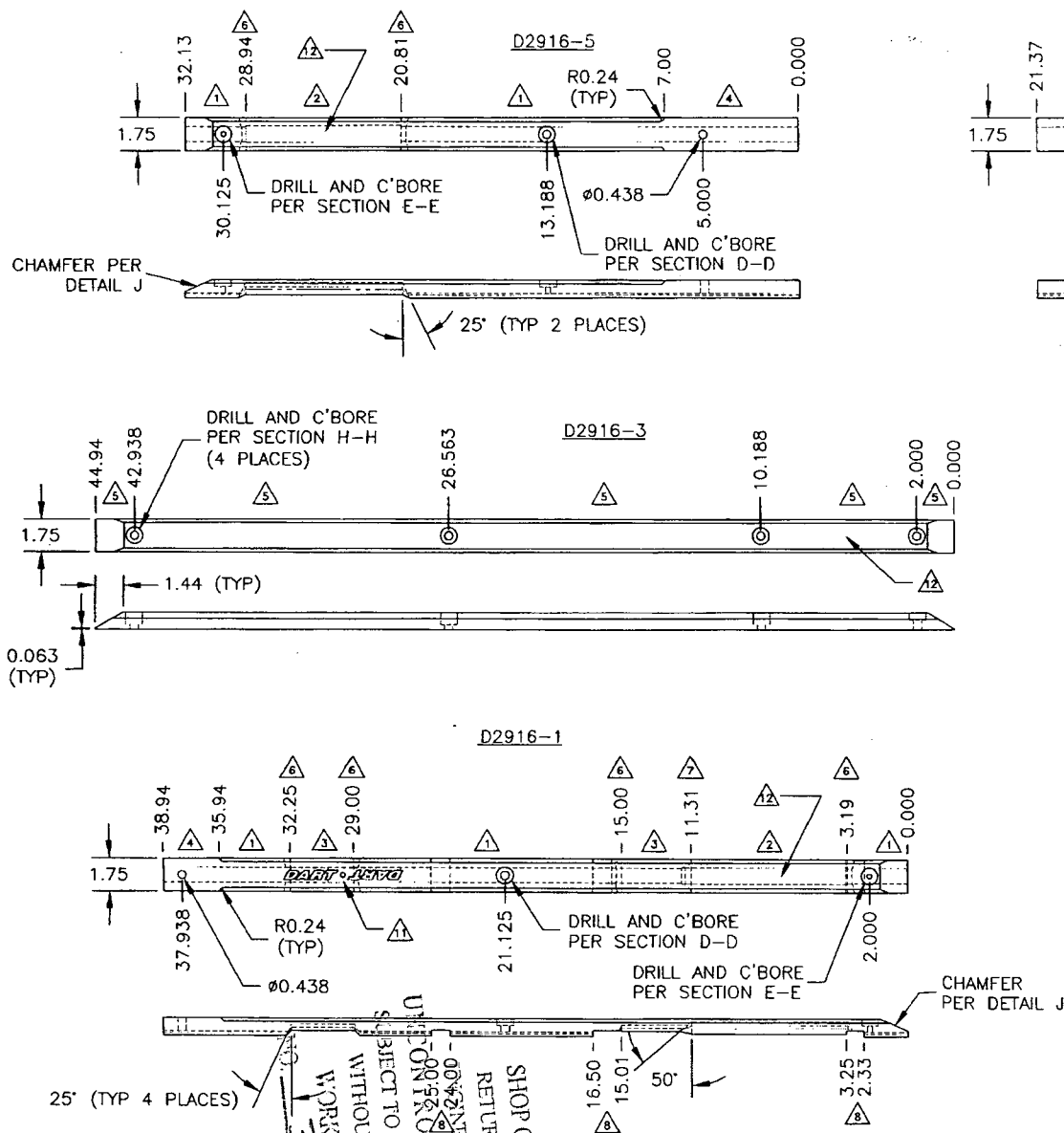


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2916	REV. B SHEET 1 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6
A	99.09.29	NEW ISSUE	
B	00.02.24	ADD K-K FOR D2521 COMPATIBILITY	



DETAIL J
(SCALE 2:3)

RELEASED
00.02.25 DS



NOTES:

- 1) MACHINE CONSTANT SECTION A-A
- 2) MACHINE CONSTANT SECTION B-B
- 3) MACHINE CONSTANT SECTION C-C
- 4) MACHINE CONSTANT SECTION F-F
- 5) MACHINE CONSTANT SECTION G-G
- 6) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 7) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 8) MACHINE SLOT PER SECTION K-K WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
- 9) MATERIAL: UHMW BLACK PER SPEC CONTROL DWG D2689
- 10) BREAK ALL UNMARKED RADII 0.020 TO 0.040
- 11) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250.
- 12) ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010.
- 13) ALL HOLES DRILLED ON CENTERLINES
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 15) ALL DIMENSIONS ARE IN INCHES

RELEASED
100.02.25 03

DESIGN #	DRAWN BY	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA	REV. B
CHECKED #	APPROVED #	DRAWING NO. D2916	SHEET 2 OF 2
DATE 00.02.24		TITLE CABLE GUARD	SCALE 1:6